

Date: Wednesday, 12/11/2008 1:32:04 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 43347	
Estimate Number : 12825	
P.O. Number :	Part Number : D3578041
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D3578 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 42821	Material :
Written By :	Due Date : 21/11/2008 Qty: 40 Um: Each
Checked & Approved By : <u>Julie Dawson 11/12</u>	
Comment : Est: A 07.04.11 New issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0074 sf(s)/Unit Total : 0.2940 sf(s)  
 6061-T6 sheet 0.080"  
 (M6061T6S080)  
 Batch: 109184 IB 8-11-17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3578 (Run prog. D3578-1)  
 Dwg Rev: A IB 8-11-17  
 Prog Rev: A

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-Open rivet holes to 0.098" and C'sink as per dwg D3578

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DOUBLER

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Part Number: D3578041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

5 08/11/18 (75)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YJ 08-11-19 x 75

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/A 08/11/19 75X

9.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nutplate

Batch: M109063

SB 08/11/19 75

10.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Rivet

M1563

SD 08/11/19 75

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3578

EP 08/11/19 75

12.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

5 08/11/20 (75)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST244 A

P 8/11/20 75

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 43347

Part Number: D3578041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/24 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

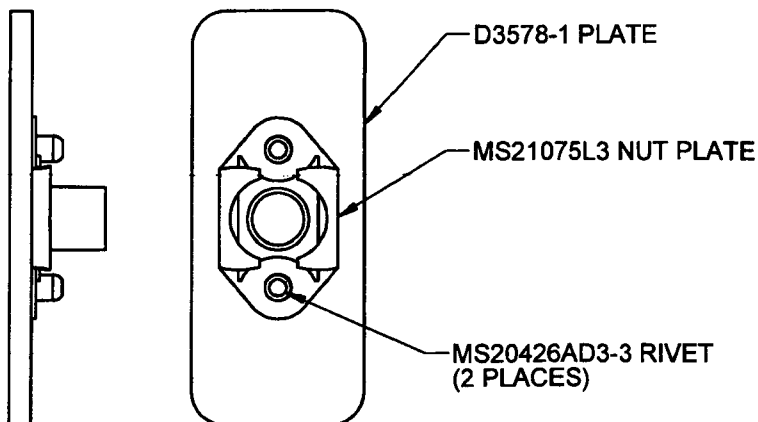
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**DART**

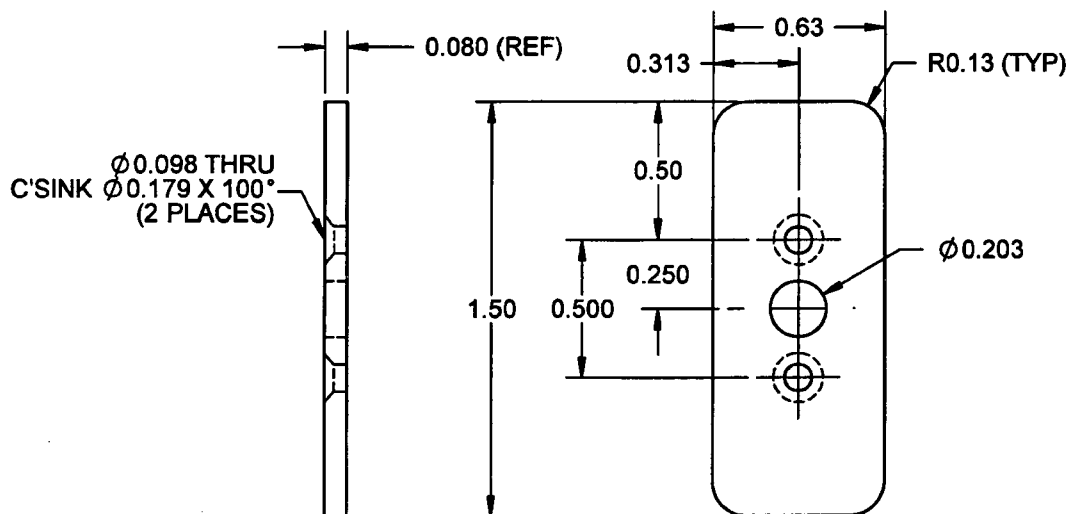
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3578</b>	REV. A SHEET 1 OF 1
DATE <b>07.01.12</b>	TITLE <b>DOUBLER</b> SCALE 3:2		
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	

**RELEASED**  
07.04.02**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

**D3578-041 DOUBLER****D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

**D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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RETURN TOUNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

NO. 4334

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